

Work Order ID 103752

June-25-13 11:50:13 AM

103752

Page 1

Item ID: D3916-5

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Light Rib

X 8 X
8
8

Start Date: 7/08/13 Start Qty: 8.00

Cust Item ID:

Required Date: 7/08/13 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-06-21

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3916	A ✓

100 0.00

100

Large Fab

Memo 0.00

X 8 13-09-26 SAD

Large Fab

1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9566
*** Make line at 9.00" annd use jig for other line***
3- Trim access tube material to finish size as per dwg D3916

110 0.00

110

QC

Quality Control

Memo 0.00

8x 84 13-10-01

120 0.00

120

Packaging

Packaging

Memo 0.00

8x 84 13-10-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear	General								
	Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced				
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up				
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure				
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld				
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled				
	Crushing	Countersink	Misaligned/off center	Positioned Wrong	Other				
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge					
	Inspection Strip in Tube	Drawing	Misread						
	Marks/Chatter	Drill Holes	Off-set						
	Turning Sequence	Finish	Out of Calibration						
	Wave/Twist in Tube	Fit/Function	Out of Sequence						

Work Order ID 103752***103752***

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June-25-13 11:50:13 AM

Item ID: D3916-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Light Rib

Start Date: 7/08/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/08/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
Description

130

QC21- Final Inspection - Work Order Release

130

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

0.00

[Signature] / Rm / 13/10/01
ML 13-10-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Other <input type="checkbox"/>
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

Picklist Print

June-25-13 11:50:13 AM

Page 1 / 1

Work Order ID: 103752

Parent Item: D3916-5

Parent Item Name: Light Rib

Start Date: 7/08/13

Required Date: 7/08/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
10.03.15 verified by:EC IPP Rev:B as per dwg revA

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	1,723.6083	4.166	35.082105	SAD	13-09-26	

Location	Loc Qty	Loc Code
WA006	1723.608273	
118460	0.00001534	
122938	0.266142	
123565	90.591216	
125062	564.509	
125502	408.2419	
M126080	660	X 39.4674

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

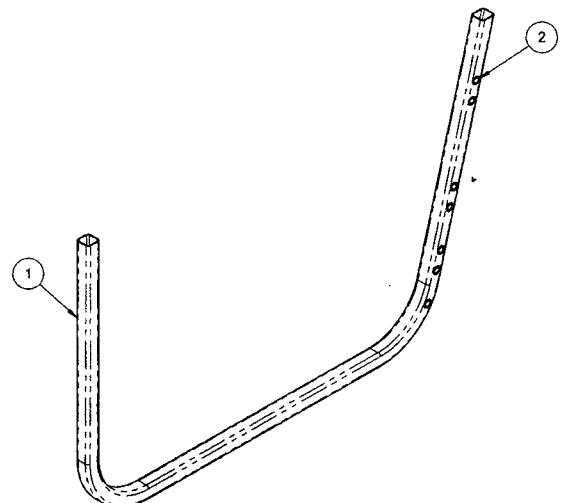
Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
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	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
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Doc/Data									
Equip/Tooling									
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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

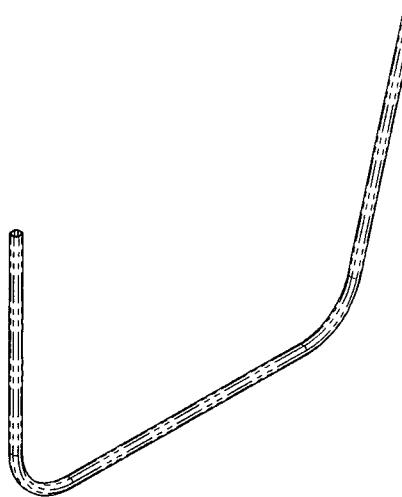
FAULT CATEGORY

Landing Gear	General	Fault Category	Action	
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Other <input type="checkbox"/>
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

ITEM	QTY	P/N	DESCRIPTION
	1	X D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

1 OF 1 COPY
 TURN TO
 MONITORING
 NO CONTROLLED COPY
 DUE TO AMENDMENT
 NO DESIGN NOTICE
 NO P/N ORDER
 103752 MUJ
 13-06-25

02-10-12-21
 UNDER REVIEW
 A10.0
 ADDITION OF HOLE + BUSHING
 ON D3916-041-1 RIBS.

RELEASED

2010-03-12

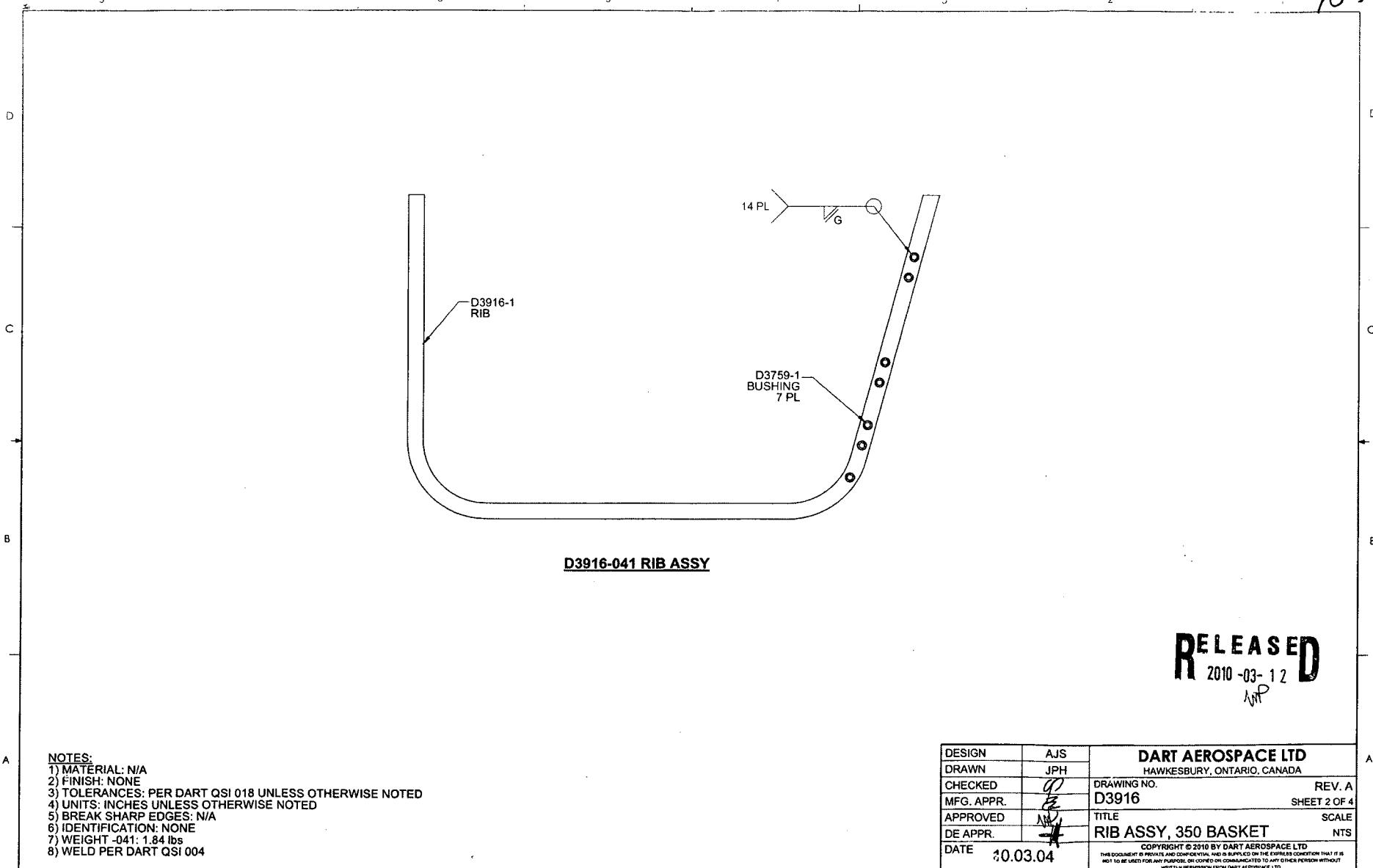
MP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	10		
MFG. APPR.	2		
APPROVED	AM		
DE APPR.	AM		
DATE	10.03.04		

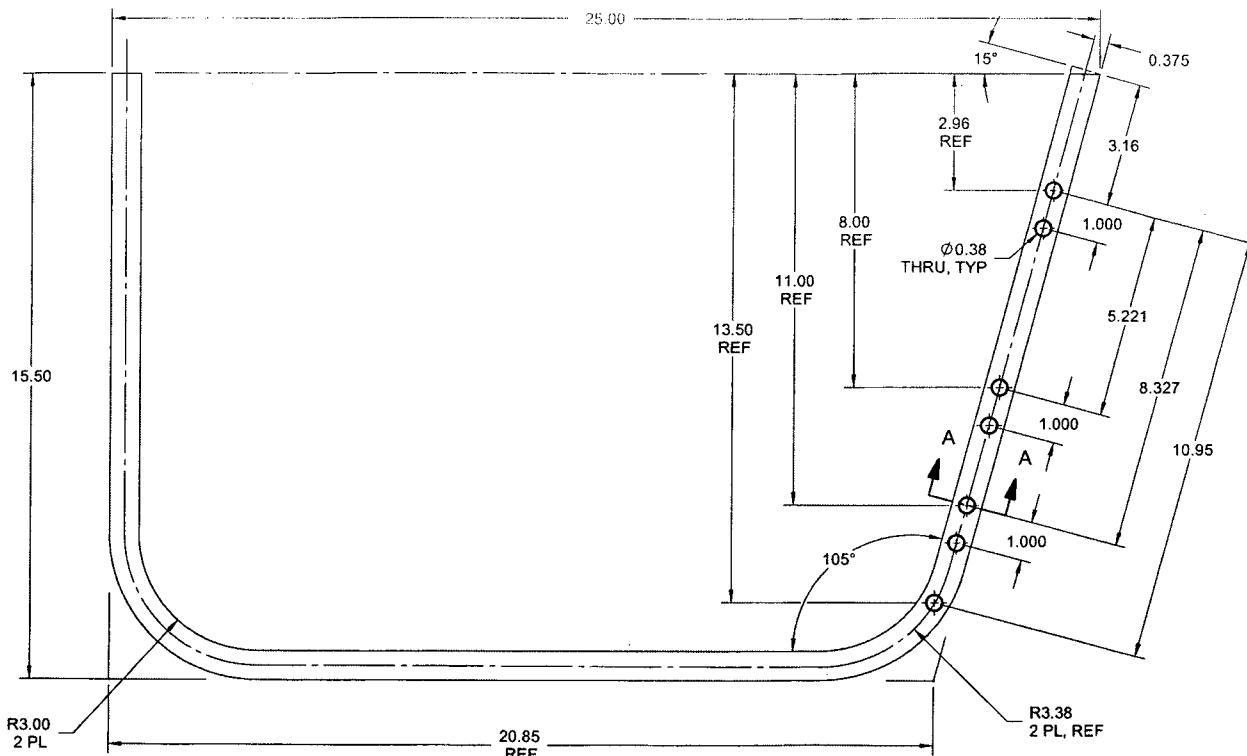
DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA
 DRAWING NO. D3916 REV. A
 SHEET 1 OF 4
 TITLE RIB ASSY, 350 BASKET NTS
 SCALE

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103752



RELEASED
2010-03-12
NP



9 D3916-1 RIB

RELEASED
2010-03-12
NPH

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PP</i>	REV. A
MFG. APPR.	<i>BB</i>	D3916
APPROVED	<i>MM</i>	SHEET 3 OF 4
DE APPR.	<i>MM</i>	TITLE
DATE	10.03.04	SCALE
		NTS

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8 7 6 5 4 3 2 1

103782

